

*Grey*  
**Process Sheet**

**Dart Aerospace Ltd.**

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SEAT BELT GUIDE ASSEMBLY
<b>Job Number</b> : 47222	
<b>Estimate Number</b> : 13859	
<b>P.Q. Number</b> :	<b>Part Number</b> : D3920041
<b>This Issue</b> : 15/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3920 PREL <i>AJS 09.04.23</i>
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : // <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : PREL
<b>Previous Run</b> :	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 17/04/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>MM 09-04-15</i>	
<b>Comment</b> : Est Rev:A New Issue 09-04-15 JLM Verified By:EC	

**Additional Product**

**PRELIMINARY ISSUE**

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6B0750X01000	6061-T6 Bar .750 x 1.00
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**Comment:** Qty.: 0.7875 f(s)/Unit    Total : 0.7875 f(s)  
6061-T6 Bar .750 x 1.00  
BATCH: *M1587*

*SP 09/04/15 ①*

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW  
Cut blank 9.25" long

*SP 09/04/15 ①*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA811 Rev: A & Dwg D3920 Rev: A

2-Deburr per dwg D3920

*H.A 09/04/16*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*H.A 09/04/16*

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

**ENGINEERING  
APPROVAL**

*RSS 09.04.16 JLM/09.04.16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT BELT GUIDE ASSEMBLY

Job Number: 47222

Part Number: D3920041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D39203

Seatbelt Guide Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Seatbelt Guide Bracket

BATCH: B47245

09.04.17

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

2- Weld assembly as per dwg D3920 & QSI 004

TRANSFER AS PER DWG D3920.

AL ROD A/R BATCH: M110972

09.04.17

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.04.17

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

09-04-17

09-04-17

(X)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 10:30am

OVEN TEMPERATURE: 320°F

FINISH TIME: 10:30am

09-04-17

09-04-17

(X)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09.04.17

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PO. #8437

09/04/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
0904.17	8.1	QCS.		0904.17	①		
		Add QCS after welding QCS.				0904.17	0904.17

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services

**Drawing Name:** SEAT BELT GUIDE ASSEMBLY

**Job Number:** 47222

**Part Number:** D3920041

Job Number:



**Seq. #:**

**Machine Or Operation:**

**Description :**

13.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/17 *[Signature]*

**Comment:** FINAL INSPECTION/W/O RELEASE

Job Completion



*C209/04/17*

**POSITIVE RECALL**

EFFECTIVE *2015*

AUTH *U*

RELEASED *ASS*

DATE *01.04.17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

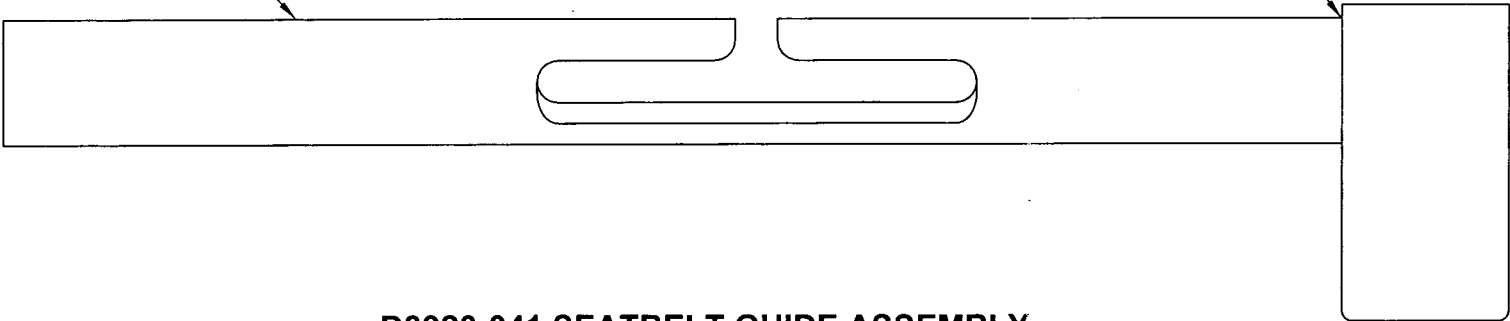
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

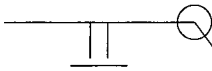


ITEM No.	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3920-041	SEATBELT GUIDE ASSEMBLY
9	1	D3920-1	SEAT BELT GUIDE
10	1	D3920-3	BRACKET

D3920-1  
SEAT BELT GUIDE



**D3920-041 SEATBELT GUIDE ASSEMBLY**



D3920-3  
SEATBELT GUIDE BRACKET  
(ASSEMBLE AT  
CHAMFERED END)

PRELIMINARY  
ISSUE  
AJS 08.04.14

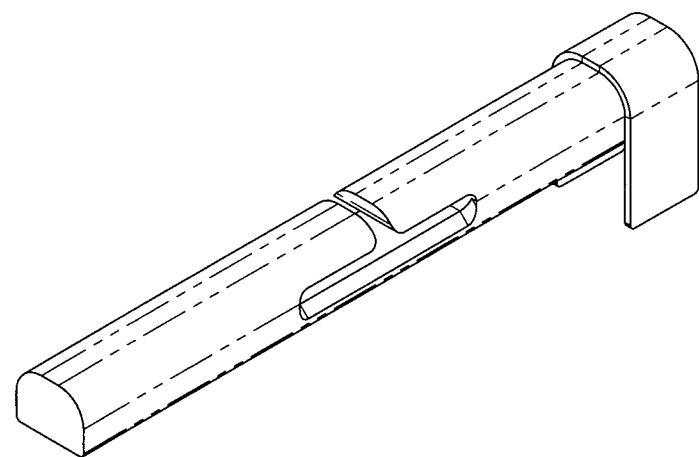
47222

**NOTES: D3920-041**

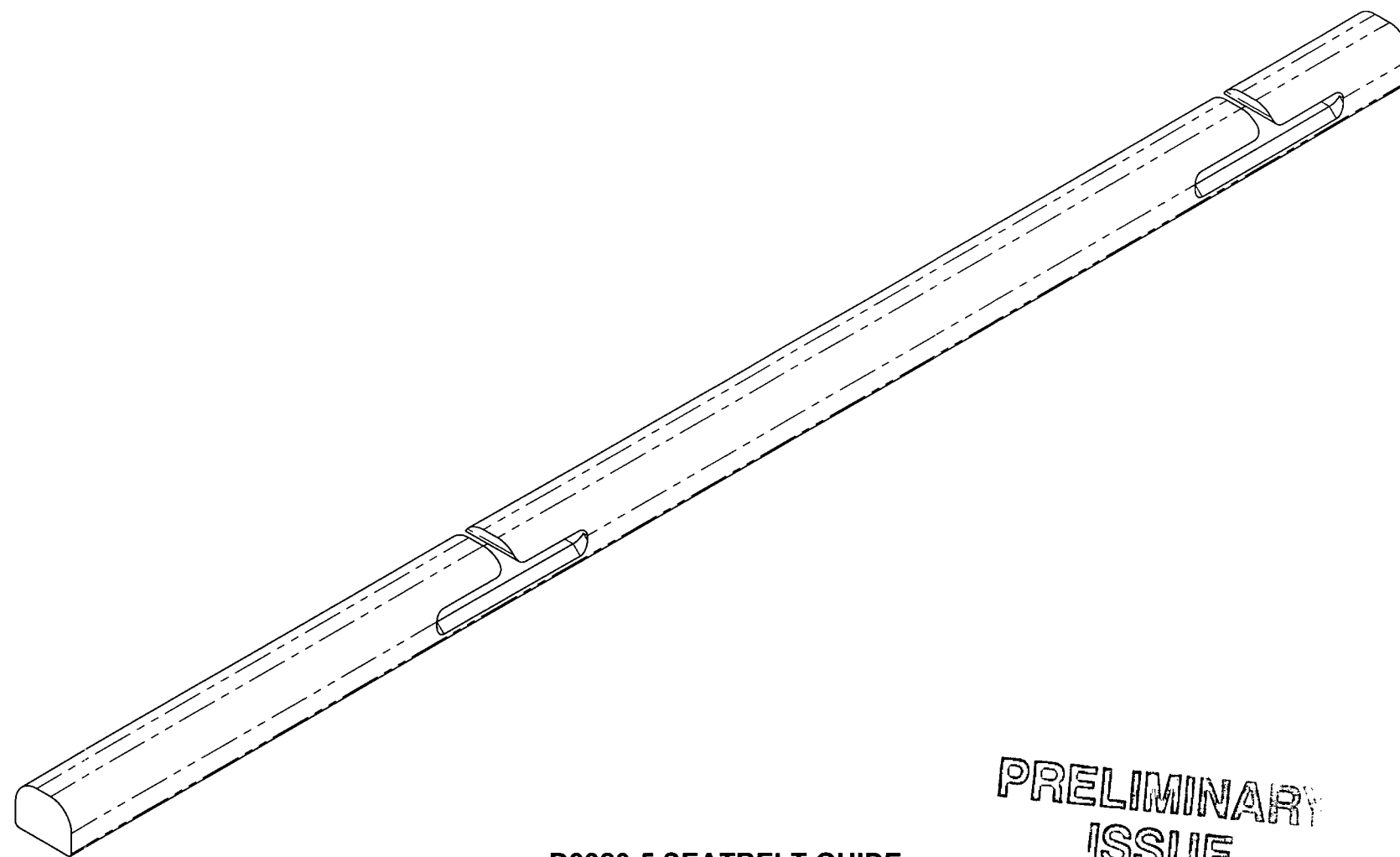
- 1) MATERIAL:
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3920-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.57 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3920	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		SEATBELT GUIDE ASSY (214B/B1)	NTS
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**D3920-041 SEATBELT GUIDE ASSEMBLY**

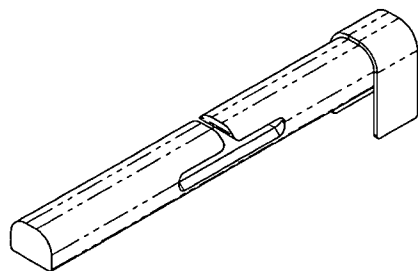


**D3920-5 SEATBELT GUIDE**

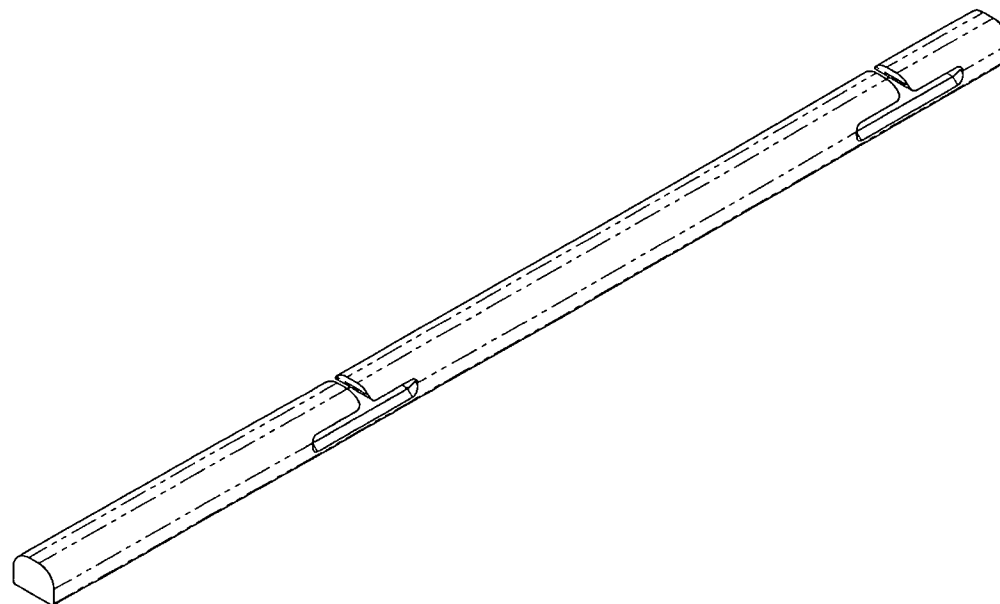
**PRELIMINARY  
ISSUE**  
AJS 06.06.14

47222

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DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3920	SHEET 1 OF 4
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**D3920-041 SEATBELT GUIDE ASSEMBLY**



**D3920-5 SEATBELT GUIDE**

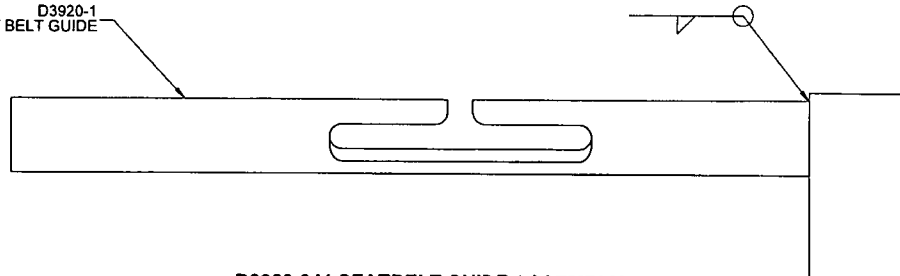
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RELEASED  
9/6/03/14

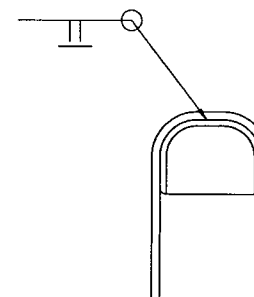
A	NEW ISSUE	AJS	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
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ITEM No.	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3920-041	SEATBELT GUIDE ASSEMBLY
9	1	D3920-1	SEAT BELT GUIDE
10	1	D3920-3	BRACKET

D3920-1  
SEAT BELT GUIDE



**D3920-041 SEATBELT GUIDE ASSEMBLY**



**D3920-3  
SEATBELT GUIDE BRACKET  
(ASSEMBLE AT  
CHAMFERED END)**

47222

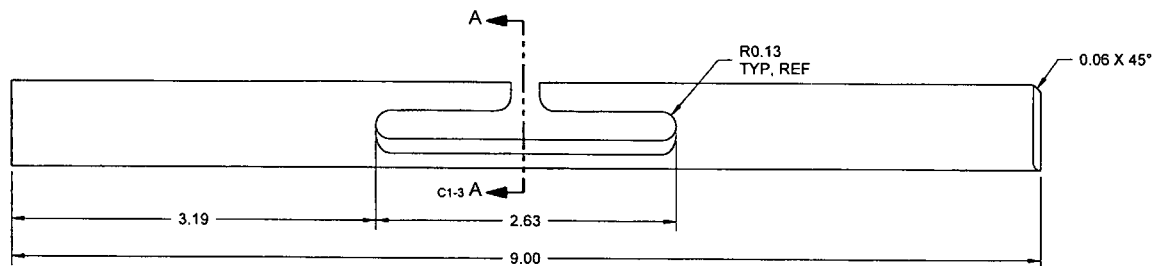
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09/04/03 N/A

**NOTES: D3920-041**

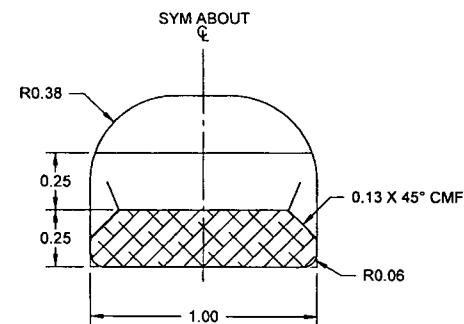
- 1) MATERIAL:
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3920-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.57 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.	21	D3920	SHEET 2 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	11	SEATBELT GUIDE ASSY (214B/B1)	NTS
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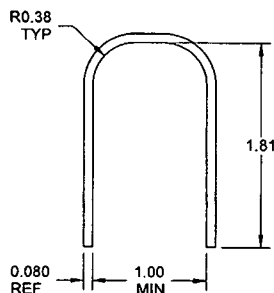
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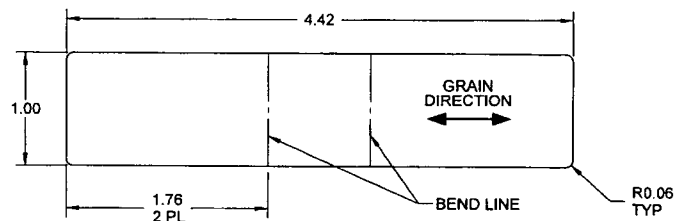
**D3920-1 SEATBELT GUIDE**



**SECTION A-A**  
C6-3  
SCALE 2X



**D3920-3 SEATBELT GUIDE BRACKET**  
(MAKE FROM D3920-3F)



**D3920-3F FLAT PATTERN**

47222

**NOTES: D3920-1&-3**

1) MATERIAL -1: 6061-T6 (OR T651/T6510/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS4160)  
REF DART SPEC M6061T6B

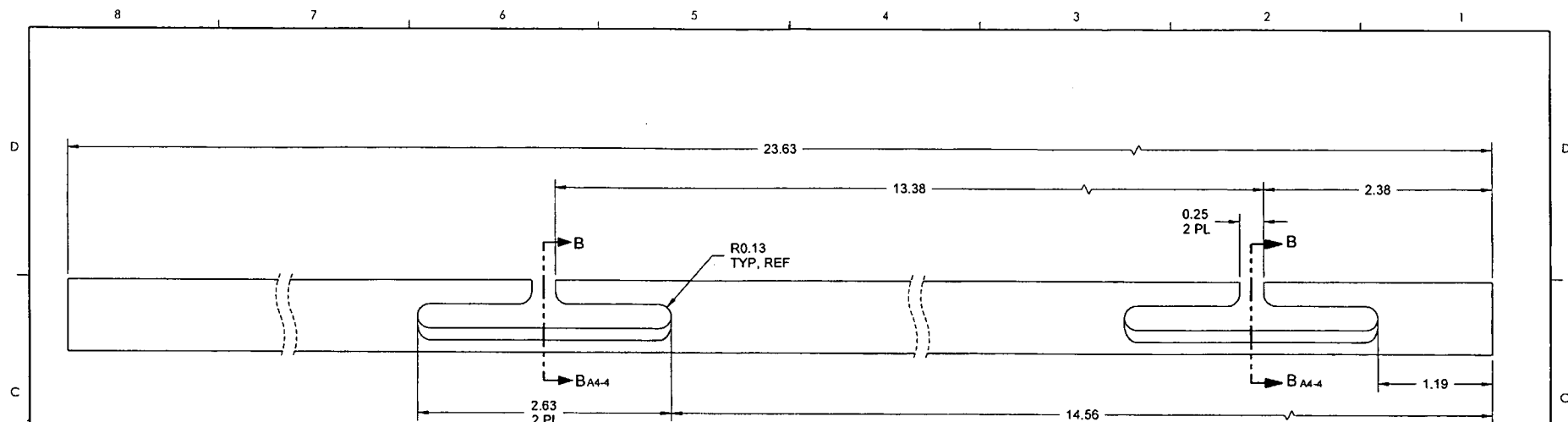
-3: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK  
PER AMS-QQ-A-250/11  
REF DART SPEC M6061T6S.080

- 2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT -1: 0.53 lbs  
-3: 0.03 lbs

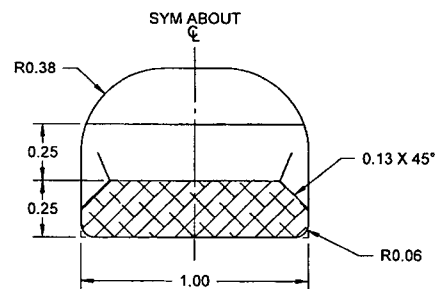
**RELEASED**  
9/6/93 NP

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3920	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SEATBELT GUIDE ASSY (214B/B1) NTS	
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8 7 6 5 4 3 2 1



**D3920-5 SEATBELT GUIDE**







**SECTION B-B C2-4 C6-4**

**NOTES: D3920-5**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS4160)  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3920-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.44 lbs

**RELEASED**

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3920	SHEET 4 OF 4
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